

%Date: Thursday, 16/10/2008 10:46:01 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 42639	
Estimate Number : 13310	
P.O. Number :	Part Number : D37931
This Issue : 16/10/2008 S.O. No. :	Drawing Number : D3793 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 42479	Material :
Written By :	Due Date : 10/11/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 08-10-16</u>	
Comment : Est Rev:A 08-05-13 new issue DD verified by:EC	
Est Rev:B 08-05-23 revA as per dwg DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.6197 sf(s)/Unit Total : 2.4788 sf(s)  
 304/316 .040 Sheet  
 (M304S20GA)  
 Batch: 109088 B 8-10-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3793  
 Dwg Rev: A B 8-10-22  
 Prog Rev: A

6

2-Deburr if necessary B 8-10-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/10/22 (6)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

CP 08/10/22 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 16/10/2008 10:46:01 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 42639

Part Number: D37931

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Joggle on brake using Jig as per Dwg D3793

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

7:30AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:00AM

JP

08-10-23

(x6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

JP

08-10-23

(x6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23 JP

Job Completion



08/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 421639
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3793-1
<b>Inspection Dwg:</b> D3793 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

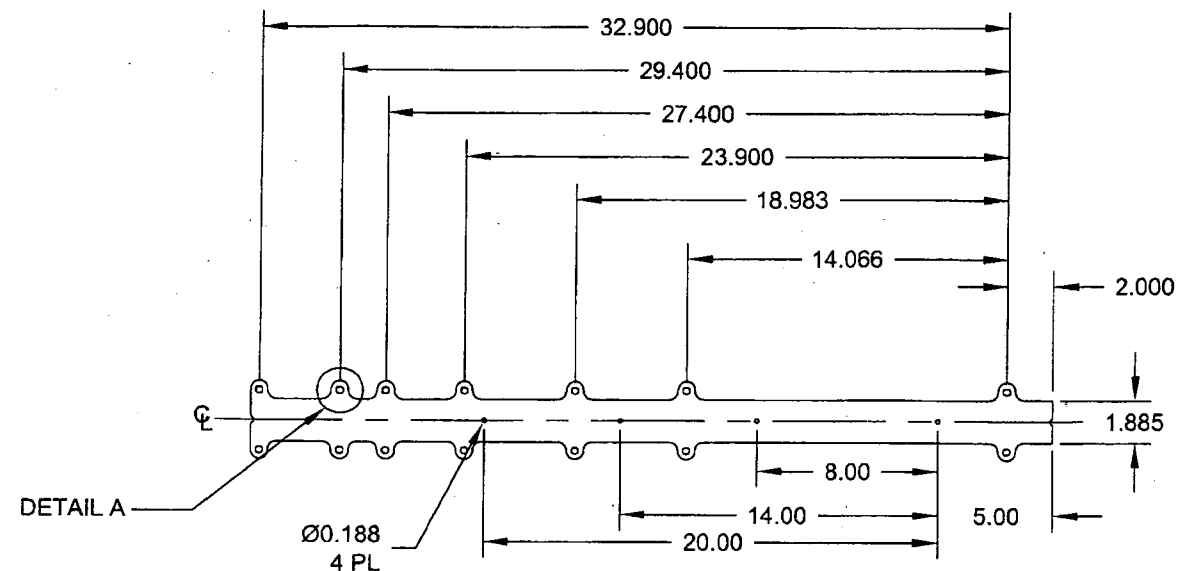
☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.188	+0.005/-0.001	.191	X			
0.300 x 0.300	+/-0.010	.303 x .303	X			
1.885	+/-0.010	1.888	X			
2.000	+/-0.010	2.003	X			
5.00	+/-0.030	5.003	X			
8.00	+/-0.030	8.00	X			
14.00	+/-0.030	14.00	X			
20.00	+/-0.030	20.00	X			
14.066	+/-0.010	14.066	X			
18.983	+/-0.010	18.983	X			
23.900	+/-0.010	23.900	X			
27.400	+/-0.010	27.400	X			
29.400	+/-0.010	29.400	X			
32.900	+/-0.010	32.900	X			
0.040	+/-0.010	.037	X			

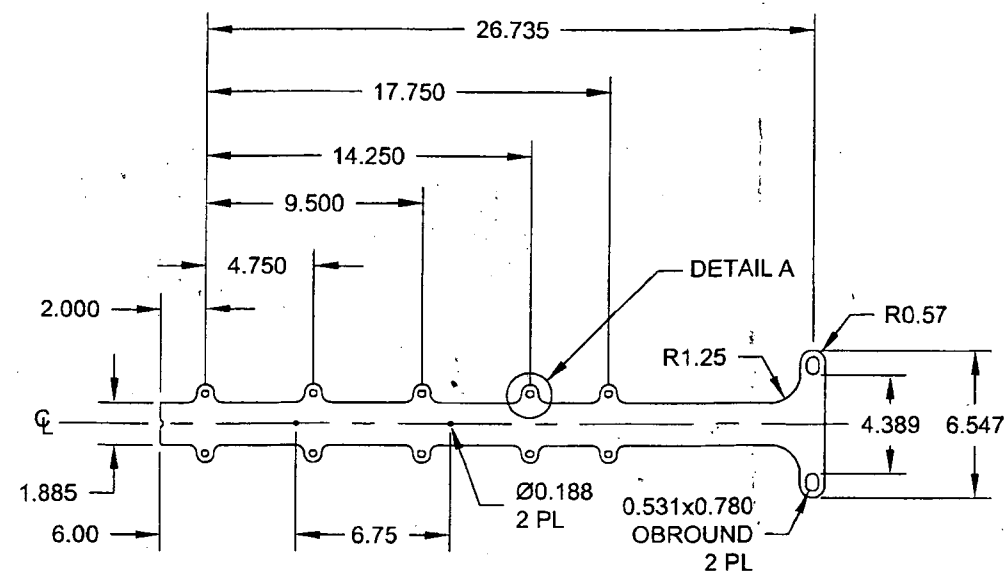
<b>Measured by:</b> JB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-10-22	<b>Date:</b> 06/10/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	DA

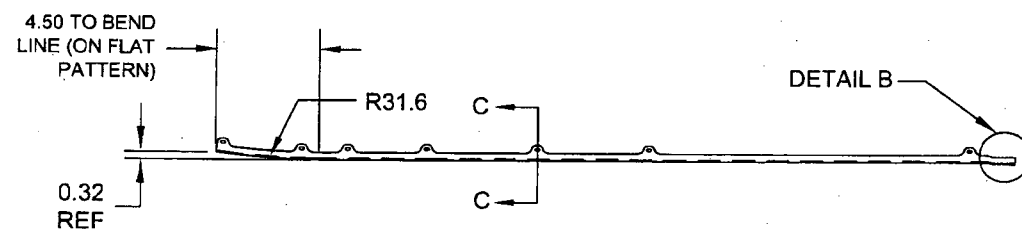
8 7 6 5 4 3 2 1



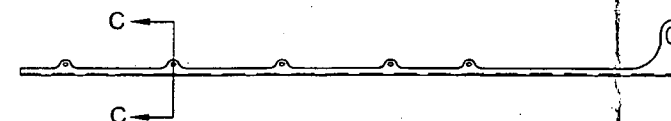
**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)






**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

**RELEASED**  
08.05.14

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42639

**NOTES:**

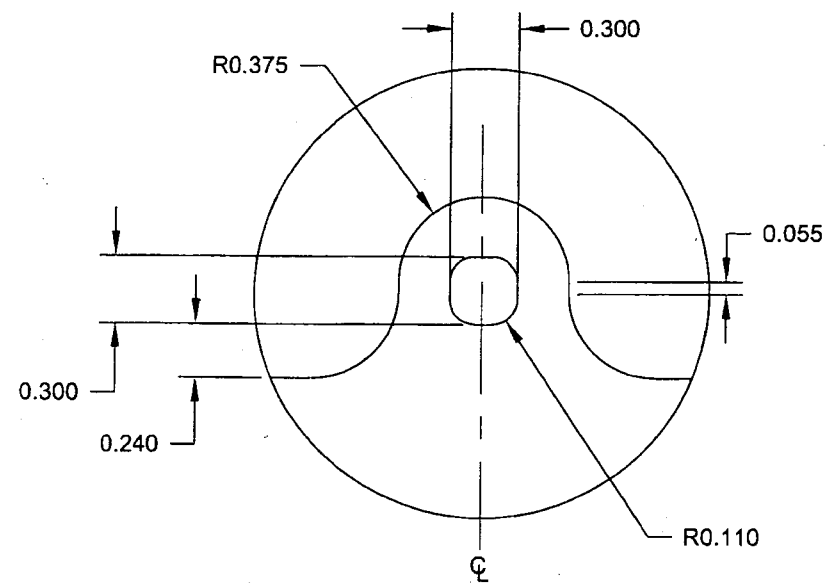
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	
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8 7 6 5 4 3 2 1

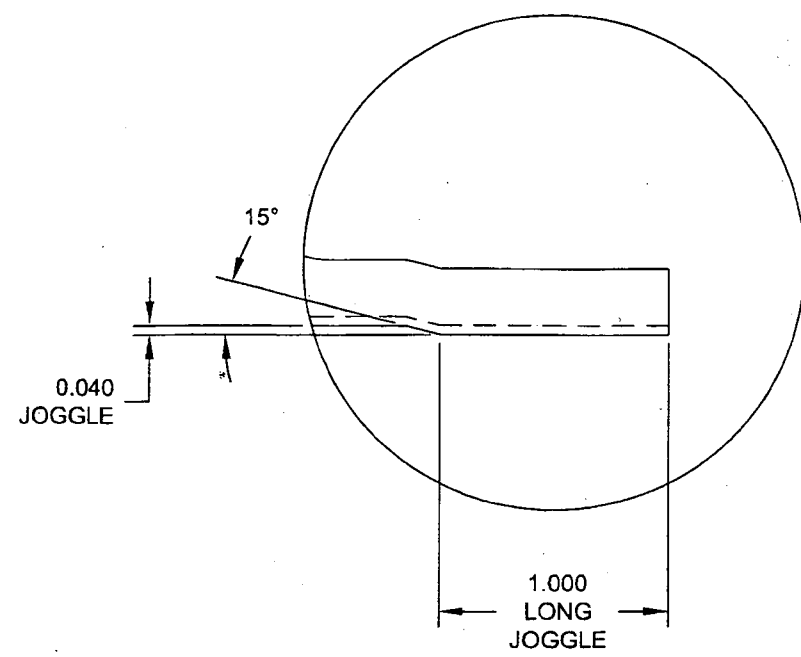
8 7 6 5 4 3 2 1

D



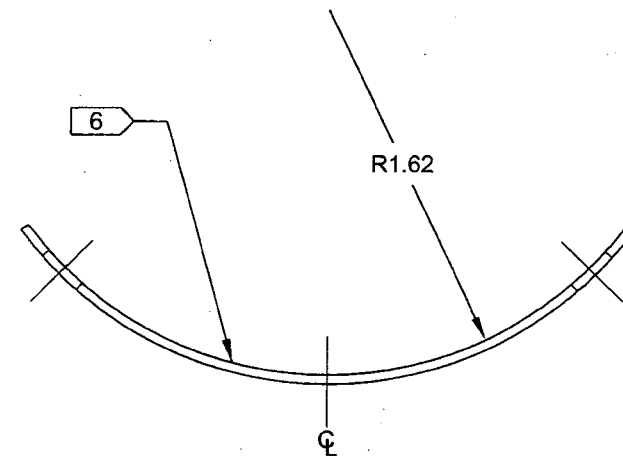
**DETAIL A**  
SCALE 10X

C



**DETAIL B**  
SCALE 10X

B



**SECTION C-C**  
SCALE 10X

A

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08-05-23

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DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
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DE APPR.		WEARSHOE	NTS
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8 7 6 5 4 3 2 1